

**Work Order ID 97719****\*97719\***

Page 1

February-21-13 12:41:36 PM

Item ID: D3913-15

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Wide Handle Plate

Stop

**\*NS2\***

Start Date: 3/05/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 3/06/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: ML5Date: 13-02-21 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date: \_\_\_\_\_ SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	B								
100		0.00							
<b>*100*</b> Waterjet									
FLOW CNC Waterjet	<b>Memo</b>	0.00							
<b>304, 125</b>	Cut as per dwg D3913 Prog Rev: <u>B</u> Dwg Rev: <u>B</u>								
	Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b> QC	<b>Memo</b>	0.00							
Quality Control									

68 0 Jm 13-3-128 0 Jm 13-3-12

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>					
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear	General											
	Bending	Bend	Grain	Ovalized	Pressure/Forced							
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
	Cuffs	Contamination	Maintenance	Part Moved								
	Heat Treat	Countersink	Mislabeled	Positioned Wrong								
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
	Ripples in Bend	Drill Holes	Offset	Other								
	Torque Waves in Extrusion	Drawing	Out of Calibration									
	Turning Sequence	Finish	Out of Sequence									
	Wave/Twist in Tube	Folio	Outside Dimensions									

**Work Order ID 97719****\*97719\***

Page 2

February-21-13 12:41:36 PM

Item ID: D3913-15

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Wide Handle Plate

Stop

**\*NS2\***

Start Date: 3/05/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 3/06/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

**\*120\***

QC

Quality Control

QC8- Inspect parts - second check

0.00

5/10

0.00

13312

8

140

**\*140\***

Packaging

Packaging

Identify as per dwg & Stock Location: 100004 0.00

0.00

8x

Sp  
13-3-12

150

**\*150\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/3/14

RB-03-13

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
				Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
				Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>			
				Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
				Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
				Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
				Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>				
				Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>	Other <input type="checkbox"/>				
				Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
				Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					
				Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>					

**Picklist Print**

February-21-13 12:41:36 PM

Page 1

**Work Order ID:** 97719**Parent Item:** D3913-15**Parent Item Name:** Wide Handle Plate**Start Date:** 3/05/13**Required Date:** 3/06/13**Start Qty:** 6.00**Required Qty:** 6.00**Comments:** IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA 304/316 0.125 Sheet	Purchased	No				100	sf	266.5500	0.1068	0.6745266 8.0			Jm13-3-12
----------------------------------	-----------	----	--	--	--	-----	----	----------	--------	------------------	--	--	-----------

Location	Loc Qty	Loc Code
MAT020	266.55	
122521	74.55	
24445	192	122521

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>					
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear	General											
	Bending	Bend	Grain	Ovalized	Pressure/Forced							
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
	Cuffs	Contamination	Maintenance	Part Moved								
	Heat Treat	Countersink	Mislabeled	Positioned Wrong								
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
	Ripples in Bend	Drill Holes	Offset	Other								
	Torque Waves in Extrusion	Drawing	Out of Calibration									
	Turning Sequence	Finish	Out of Sequence									
	Wave/Twist in Tube	Folio	Outside Dimensions									

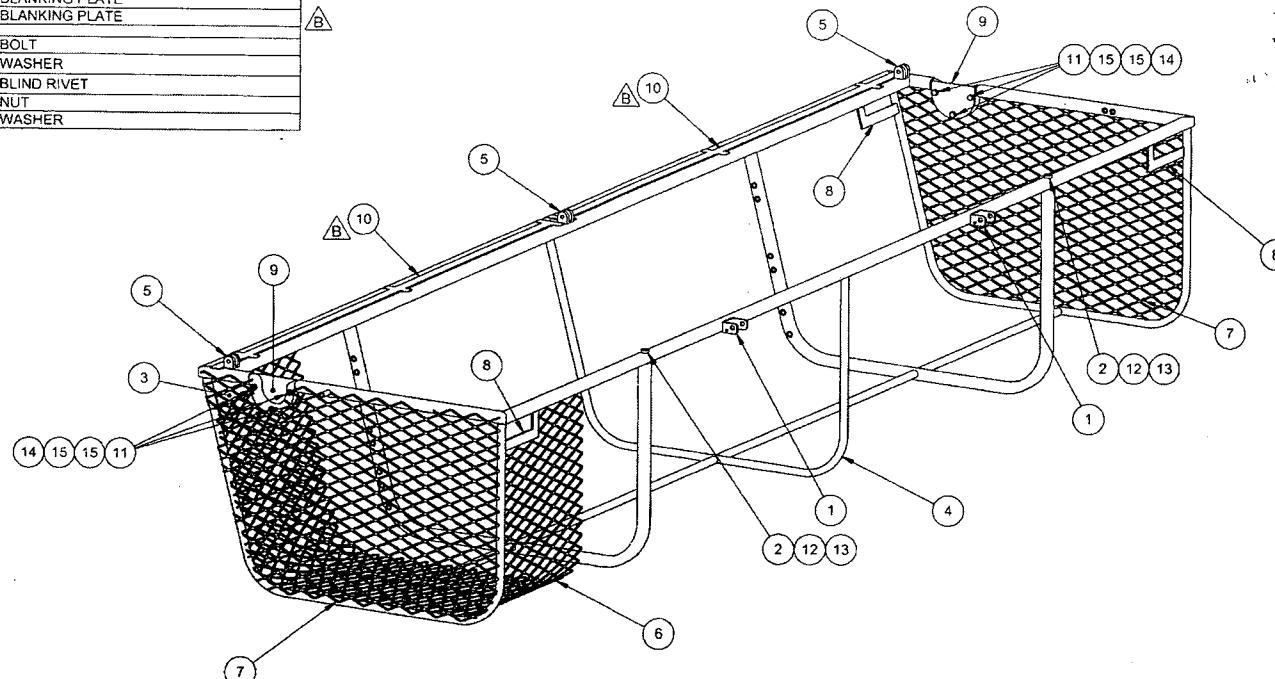
DART AEROSPACE LTD	Work Order:	97719
Description: Wide Handle Plate	Part Number:	D3913-15
Inspection Dwg: D3913	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>Jm</u>	Audited by: <u>SMJ</u>	Preliminary Approval:
Date: <u>13-3-12</u>	Date: <u>13/3/12</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	12.07.31	Dwg Rev updated	KJ	

ITEM	QTY	P/N	DESCRIPTION
	1	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

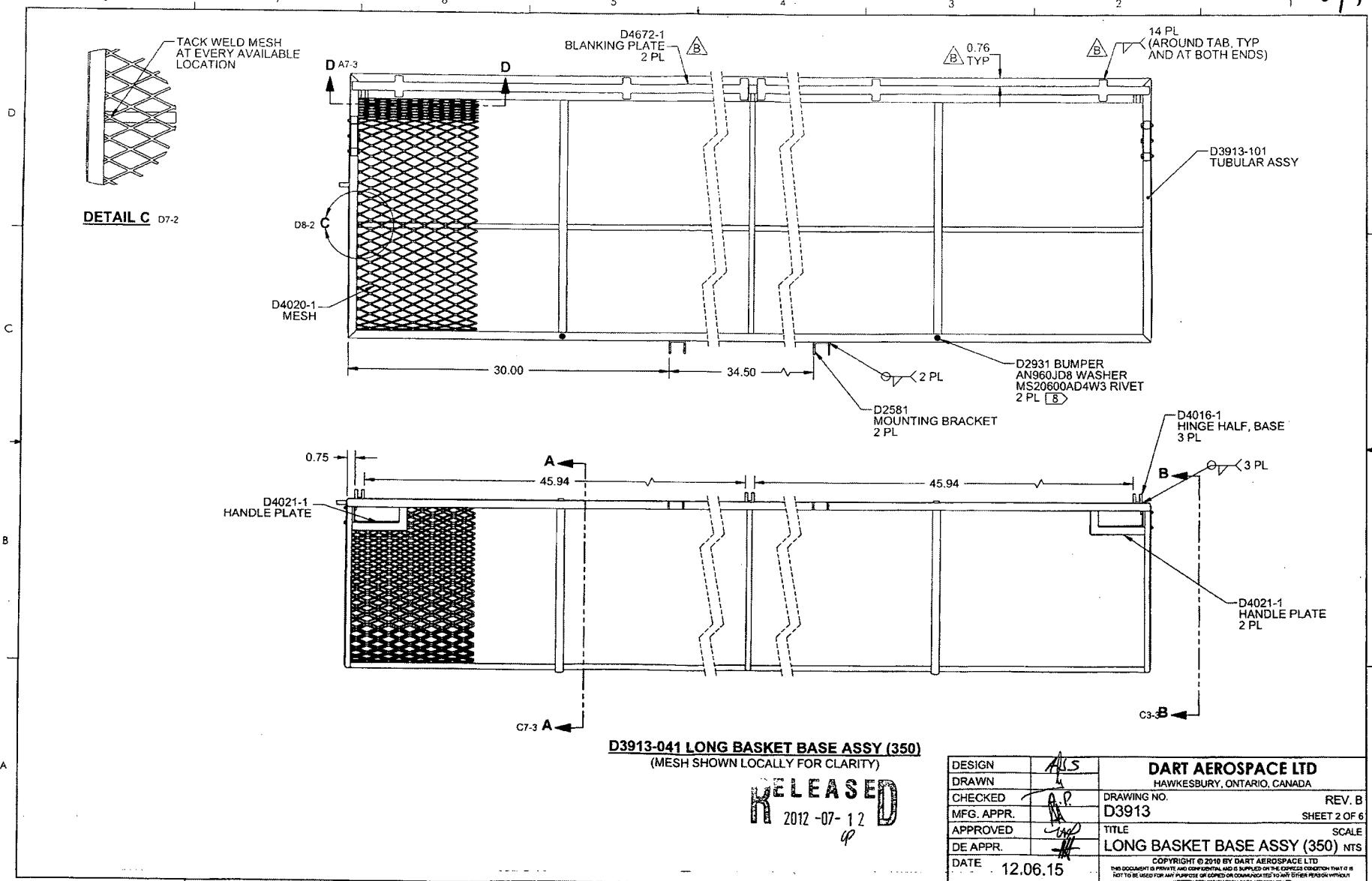
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2012-07-12  
JPH  
ECN 12-64

B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2)	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	1/5	<b>DART AEROSPACE LTD</b>	
DRAWN	1/5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/5	DRAWING NO.	REV. B
MFG. APPR.	1/5	D3913	SHEET 1 OF 6
APPROVED	1/5	TITLE	SCALE
DE APPR.	1/5	LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT CONTAINED HEREIN IS UNCLASSIFIED AND MAY BE COPIED AND DISTRIBUTED INDEFINITELY PROVIDED THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

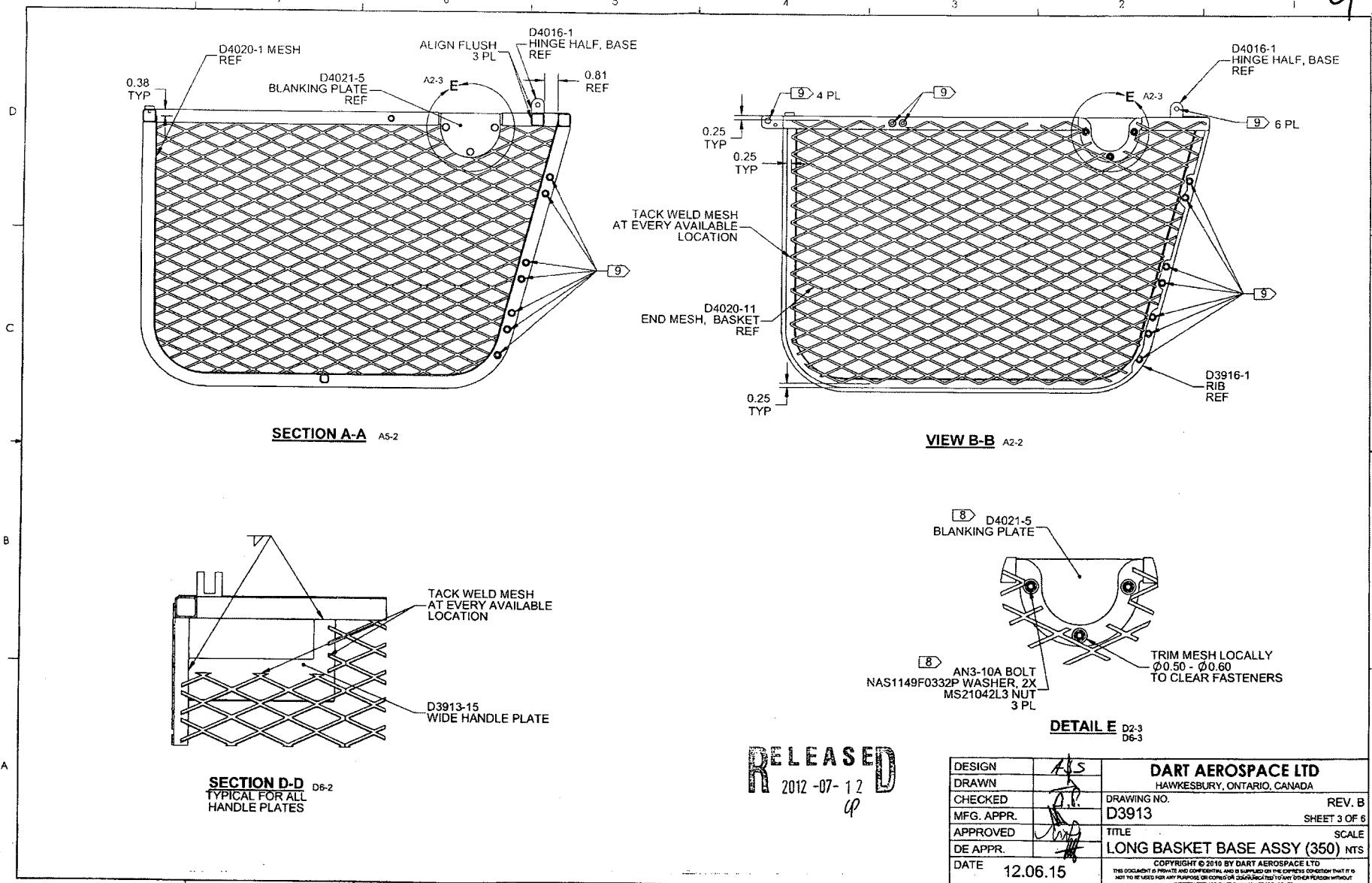
93719



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

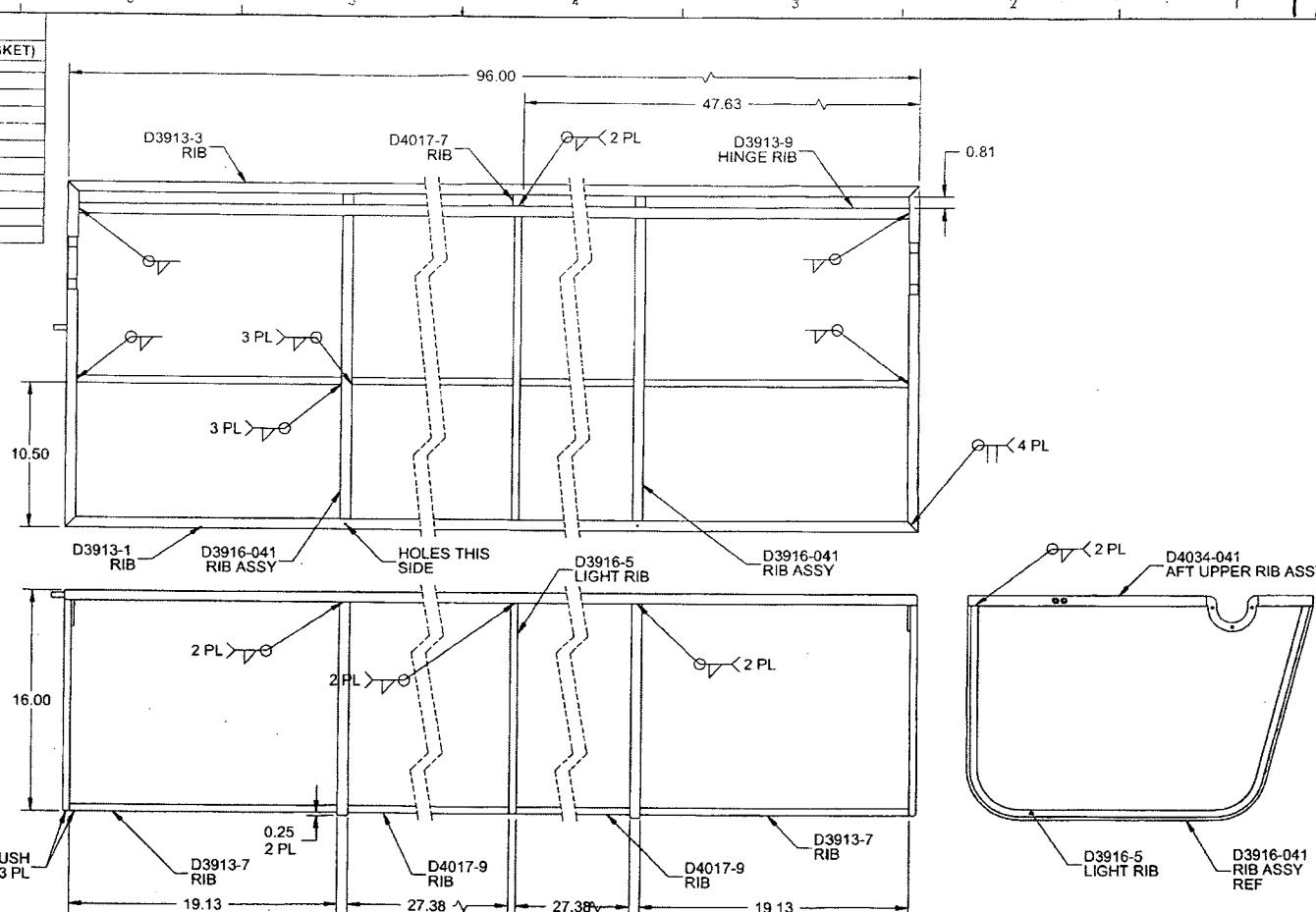
RELEASED  
2012-07-12  
P

DESIGN	<u>115</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	<u>A.P.</u>	DRAWING NO.	REV. E	
MFG. APPR.		D3913	SHEET 2 OF	
APPROVED	<u>Jay</u>	TITLE	SCALE	
DE APPR.	<u></u>	LONG BASKET BASE ASSY (350) NTS		
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		



97719

ITEM	QTY	P/N	DESCRIPTION
	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 LONG BASKET)

## NOTES:

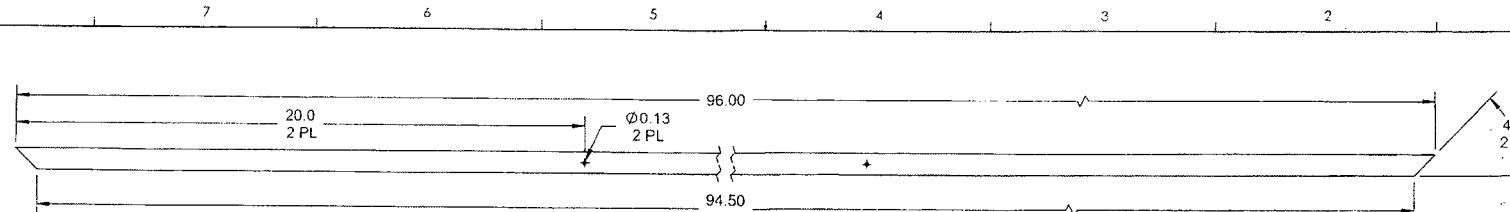
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

RELEASED  
2012-07-12  
D

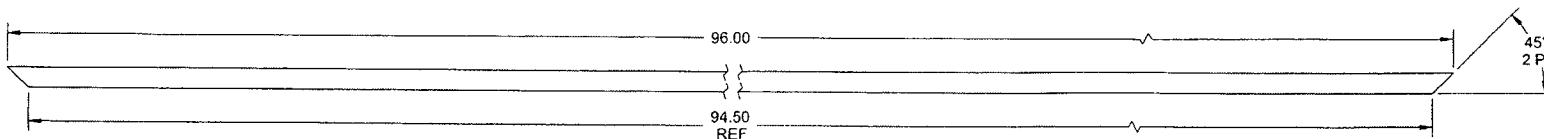
DESIGN	ALS
DRAWN	A.D.
CHECKED	A.D.
MFG. APPR.	W.M.
APPROVED	W.M.
DE APPR.	W.M.
DATE	12.06.15

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. D3913  
REV. B  
SHEET 4 OF 6  
TITLE: LONG BASKET BASE ASSY (350) NTS  
SCALE: 1:1  
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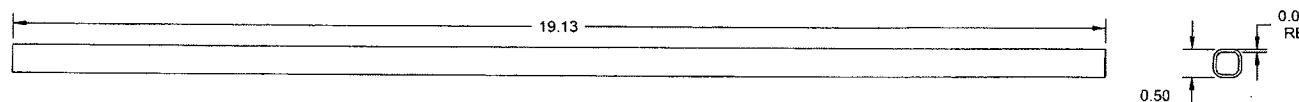
9779



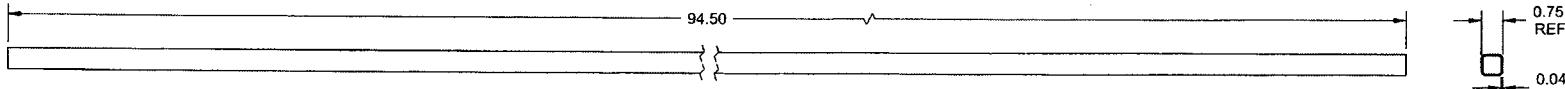
D3913-1 RIB



D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB

## NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.500W.049

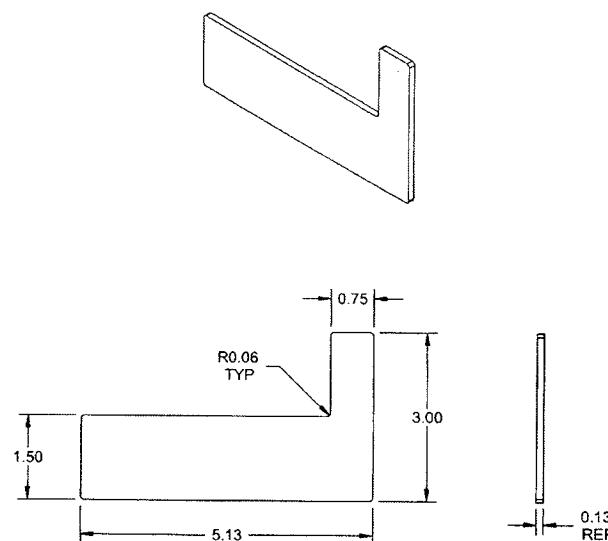
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED  
2012-07-12  
IP

DESIGN	AS	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	IP	DRAWING NO. D3913
MFG. APPR.		REV. B
APPROVED		SHEET 5 OF 6
DE APPR.		TITLE
DATE	12.06.15	SCALE

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97719



D3913-15 WIDE HANDLE PLATE

## NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED  
2012-07-12  
CP

DESIGN	4.5	DART AEROSPACE LTD
DRAWN	4.5	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.V.	DRAWING NO. D3913
MFG. APPR.		REV. B
APPROVED		SHEET 6 OF 6
DE APPR.		TITLE
DATE	12.06.15	SCALE
		LONG BASKET BASE ASSY (350) NTS

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